E

Lug

Page 1

Tuesday, September 22, 2009 2:32:12 PM

Item ID: **Revision ID:** D2249-1

Accept

Setup Start



Stop

Item Name: **Start Date:**

9/23/2009

Start Qty: 20.00

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

Required Date: 10/9/2009

MV Date 9-9-27 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID Operation Description Set Up/

Draw Number

Accept

Reject

Reject Number

Draw Nbr D2249

Rev E

Revision Nbr

0.00



FLOW CNC Waterjet

FLOW WATER JET

□Dwg Rev:_

0.00

□Prog Rev: **E** □2-

1-Cut as per Dwg D2249 Deburr if necessary

Memo

B 9-10-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

1-139-10-19

0.00

Quality Control

120

QC8- Inspect parts - second check

Memo

0.00 2) 809/10/12

Quality Control

Memo

Run Hours

Draw Rev.

Plan Code

Qty

Qty

Insp. Stamp

Work Order ID 52300



Page 2

Tuesday, September 22, 2009 2:32:12 PM

Item ID: **Revision ID:** D2249-1

Ε

Item Name: Lug

Start Date:

9/23/2009 Required Date: 10/9/2009

Start Oty: 20.00 Reg'd Oty: 20.00



Accept

Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

SPC (Y/N):

Tooling: Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location Ca

Memo

Run Hours 0.00

Set Up/

0.00

Draw Number

Draw Plan Rev. Code

Accept **Qty**

Reject Qty

Reject Number

Insp. Stamp

140

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/30

N 57.10.30

Picklist Print

Tuesday, September 22, 2009 2:32:12 PM

Work Order ID: 52300

Parent Item: D2249-1RevE

Parent Item Name: Lug

Comments:



111323

Start Date: 9/23/2009

111333

Required Date: 10/9/2009

1B 9-10-19

Page 1

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	205.2400	1.8105			
		•									B 9-10.	49

304/316 Sheet .063

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	205.2399737		
106860	16.018		
111924	25.1689737		
112442	68.053		
112567	96		

DART AEROSPACE LTD	Work Order:	32300
	5(1)	D0040.4
Description: Lug	Part Number:	D2249-1
Inspection Dwg: D2249 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

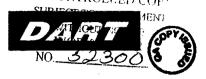
X First	t Article	Prototype
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<u></u>
<u> </u>
· ·

Measured by:	18	Audited by:	Prototype Approval:	N/A
Date:	9-10-19	Date: orlos	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.23	New Issue	KJ/JLM O	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\

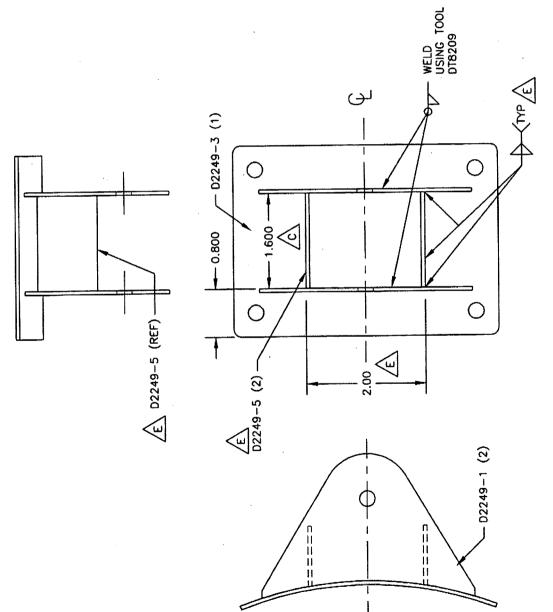
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COF



-	DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
1	CHECK	(ED	APPROVED	DRAWING NO.	REV. E
		KE	1	D2249 SHEET	1 OF 4
	DATE	¥	1 31	TITLE	SCALE
***************************************	99.0	9.20		FITTING	NTS
	Α		94.06.20	NEW ISSUE	
	В		95.11.30	DIMENSION CHANGE	

RELEASED 199.10.12 RE

ı	DATE	<u> </u>	1	TITLE	SCALE
	i	9.20		FITTING	NTS
	Α		94.06.20	NEW ISSUE	
	В		95.11.30	DIMENSION CHANGE	
	С		95.12.14	DIMENSION CHANGE	
	D		98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
	Ε		99.09.20	ADDED GUSSET	



D2249-041 ASSEMBLY

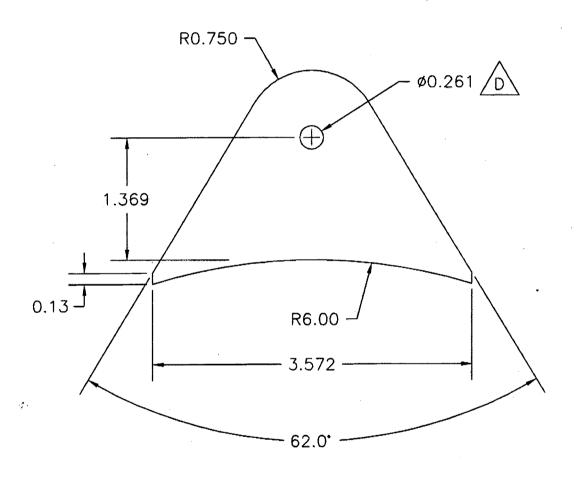
MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED





DESIGN	PF		ROSPACE RY, ONTARIO, CANA		
CHECKED	APPROYED	DRAWING NO.			REV. E
RE	 	D2249		SHEET	2 OF 4
DATE		TITLE			SCALE
99.09.20		FITTING			1:1



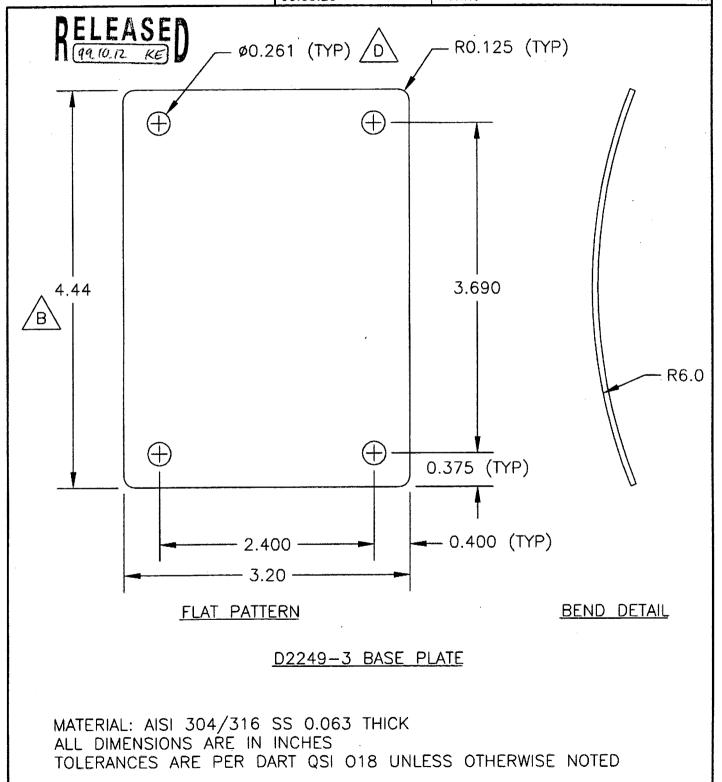


D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROYED	DRAWING NO.	REV. E
KE	 	D2249	SHEET 3 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1

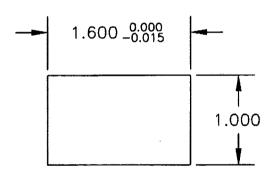






DESIGN	DRAWN BY		OSPACE LTD , ontario, canada
CHECKED	APPROVED	DRAWING NO.	REV. È
KE	#	D2249	SHEET 4 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1





D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED